

Date: Monday, 22/09/2008 2:00:39 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 42191
 Estimate Number : 10290
 P.O. Number :
 This Issue : 22/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3121144
 Drawing Number : D3121 REV E
 Project Number : N/A
 Drawing Revision : E
 First Issue : / / Type : MACHINED PARTS
 Material :
 Due Date : 25/10/2008 Qty: 25 Um: Each
 Previous Run : 40344
 Written By :
 Checked & Approved By :
 Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS
 Est Rev: B ECN 1060 07-11-12 DD verified by: EC
 Est Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified
 By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B1250X02000 17-4 SS Bar 1.250 x 2.00



Comment: Qty.: 0.3864 f(s)/Unit Total: 9.6600 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.250 x 02.000)
 Identify for D3121-114
 Batch: M109457

J.L 08/10/01

2.0 BAND SAW BAND SAW



Comment: BAND SAW 1.250
 Cut blanks: (1.000" x 2.000") 4.425" long

J.L 08/10/01

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-114 as per Folio EA330 and Dwg D3121 Identify as D3121-114

2-Deburr

3-Scribe batch number

J.L/J.F. 08/11/27

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L/J.F. 08/11/27

(25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-144 PAR #: N/A Fault Category: Prod - Mech. NCR: (Yes) No DQA: A Date: 08.12.04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: X Date: 08/12/04

NCR: 42191		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/27	3	1 part to scrap the spigot to small. Part 0.100" off. R.C: Material was not positioned correctly upon set-up. Hummer error.	<u>[Signature]</u> 08/11/27	destroy and replace Qty x 1 Batch: <u>109021</u>	<u>[Signature]</u> 08/11/27	<u>[Signature]</u> 08/12/03	<u>[Signature]</u> 08/11/27	<u>[Signature]</u> 08/11/27

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:00:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42191

Part Number: D3121144

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

SECOND CHECK



Comment: SECOND CHECK

Inspect here *S N/A*

J.L 08/12/01

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt

B42201

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-241 Bearing Ass

B42177

8/12/03

50
(25x)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-143 as per Dwg D3121.

8/08/12/03 (25)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/10/03 (x25)
counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 233

8/08/12/03 (x25)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/04

Job Completion



MF 08-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

42191

DART AEROSPACE LTD		Work Order: 11575
Description: Bracket		Part Number: D3121-114
Inspection Dwg: D3121	Rev: E	Page 1 of 2

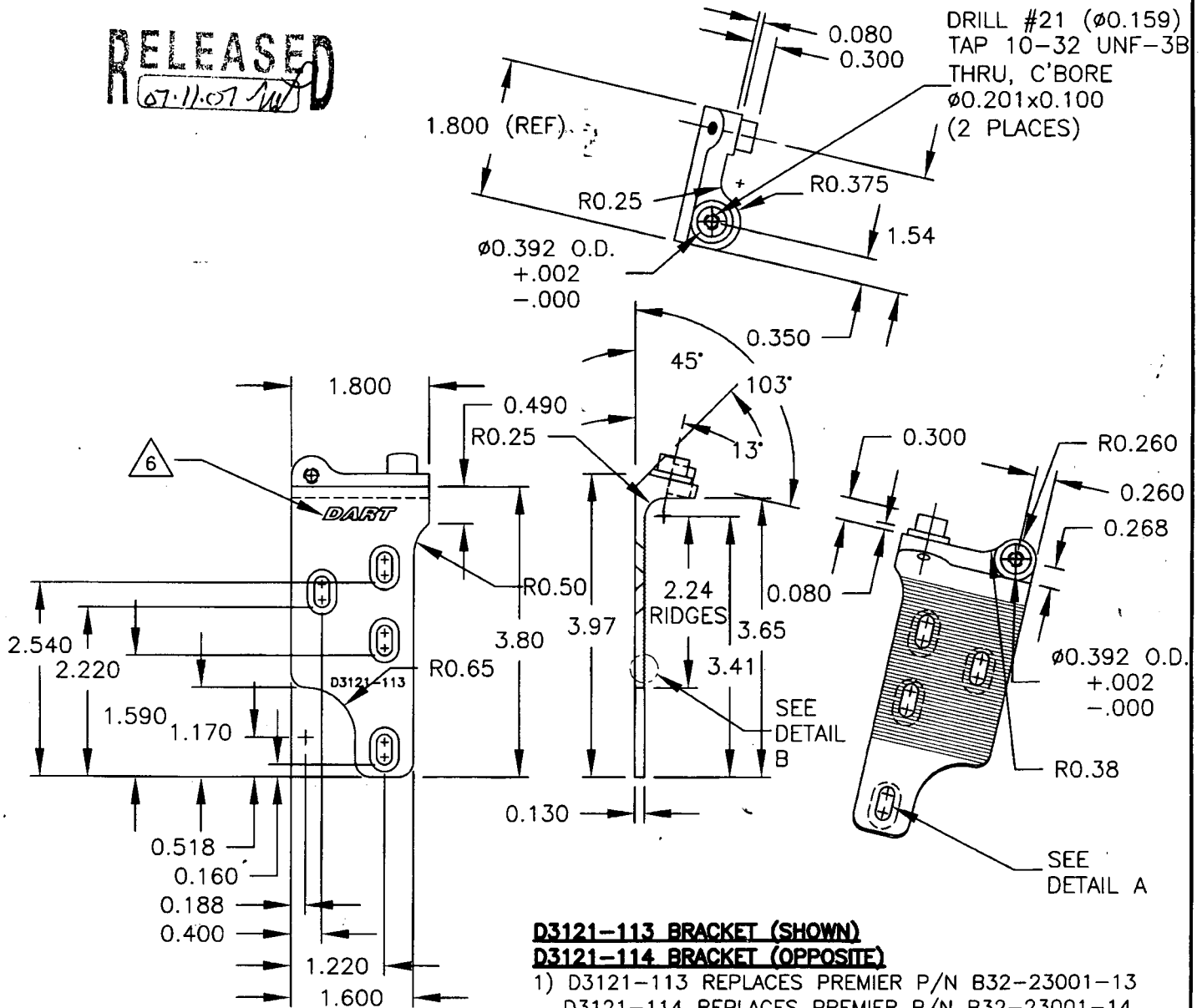
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.081"	✓			
0.300	+/-0.010	.296"	✓			
R0.375	+/-0.010	R.375"	✓			
1.54	+/-0.030	1.540"	✓			
0.350	+/-0.010	.351"	✓			
R0.25	+/-0.030	R.250"	✓			
Ø0.392	+0.002/-0.000	Ø.393"	✓			
Ø0.201	+0.005/-0.000	Ø.200"	✓			
0.100	+/-0.010	.099"	✓			
2.540	+/-0.010	2.540"	✓			
1.590	+/-0.010	1.590"	✓			
0.160	+/-0.010	.161"	✓			
0.400	+/-0.010	.404"	✓			
1.220	+/-0.010	1.225"	✓			
1.600	+/-0.010	1.605"	✓			
3.80	+/-0.030	3.809"	✓			
1.800	+/-0.010	1.804"	✓			
R0.50	+/-0.030	R.500"	✓			
0.130	+/-0.010	.132"	✓			
3.41	+/-0.030	3.383"	✓			
3.65	+/-0.030	3.640"	✓			
2.24	+/-0.030	2.210"	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	R.250"	✓			
3.97	+/-0.030	3.973"	✓			
R0.38	+/-0.030	R.380"	✓			
Ø0.392	+0.002/-0.000	Ø.393"	✓			
Ø0.201	+0.005/-0.000	Ø.200"	✓			
0.268	+/-0.010	.269"	✓			
R0.260	+/-0.010	R.260"	✓			
0.080	+/-0.010	.080"	✓			
0.300	+/-0.010	.298"	✓			
0.381	+/-0.010	.381"	✓			
0.201	+/-0.010	.199"	✓			

DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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